

Work Order ID 69817

Thursday, May 19, 2011 2:31:54 PM



Page 1

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 5/19/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

P

Date: 11-05-19

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-Deburr if necessary

304.063

B11-5-26

64

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-26

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sum 5/27

QC8
x60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

SP 11/05/20

(60)

140

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
M117659 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary

EL 11-6-7 X60

150

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

S 11/06/08

cant
(460)

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5 ulobob

counts

x600

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

60x 11/06/08

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

60 & BK 11-6-8

N115128

9:15
3200F
9:45

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Packaging	Identify as per dwg & Stock Location: <i>FP-17.</i> Memo	0.00 0.00				<i>60</i>	<i>4</i>	<i>BL</i>	<i>11-6-8.</i>
200 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/6/99</i> <i>CMF</i> <i>11-06-08</i>

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, May 19, 2011 2:31:59 PM

Page 1

Work Order ID: 69817



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 5/19/2011

Required Date: 5/25/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

192.8000

0.106

6.694737

6.7



1311-5-26

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

192.8

117275

32.8

117653

160

117653

(60)

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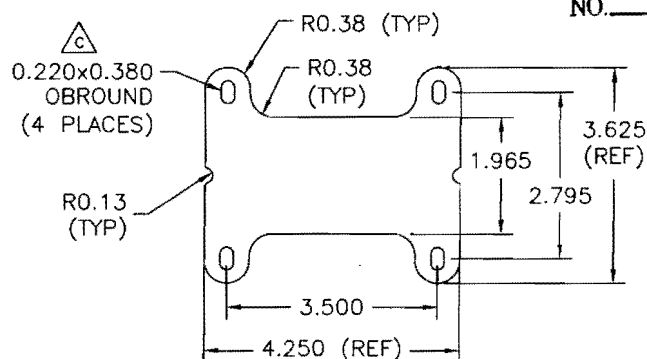
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SHOP COPY
RETURN TO
ENGINEERING
~~UNCONTROLLED COPY~~
SUBJECT TO AMENDMENT

69817 11-05-19

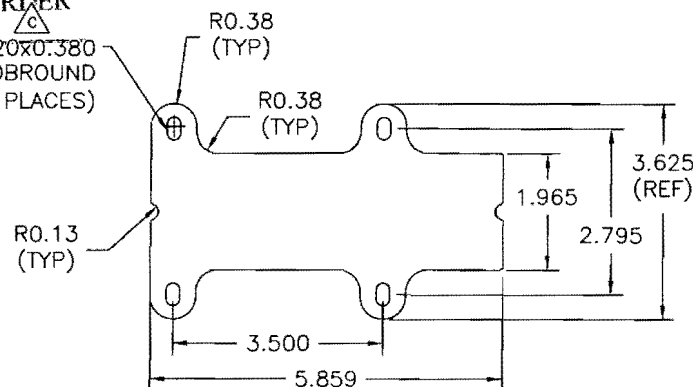
D3537-1F FLAT PATTERN



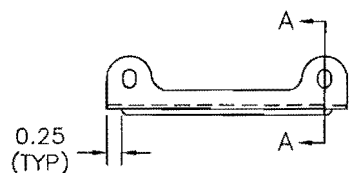
WITHOUT NOTICE
WORK ORDER

NO. 0.220x0.380
OBROUND
(4 PLACES)

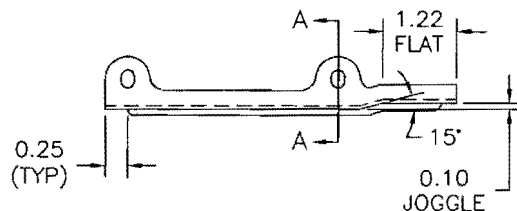
D3537-3F FLAT PATTERN



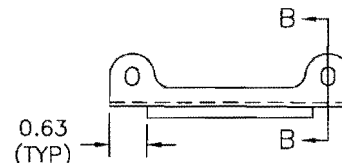
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



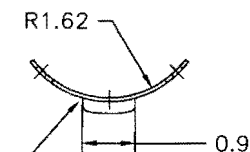
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

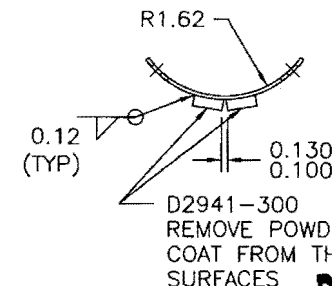


SECTION A-A

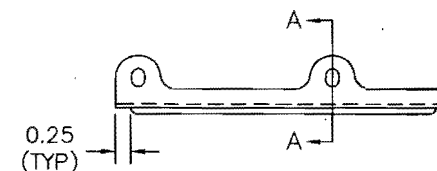


APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

RELEASED
07.05.08 Ad
per ELN
962

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